

Work Order ID 76431

76431

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Monday, November 14, 2011 10:58:59 AM

Item ID: D407-802-017 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Passenger Door Opener Installation, LH
 Start Date: 11/14/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/17/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 11-11-14 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------------|--------------|
| IIN-D407-802-1 | A |

100 0.00
100 DOCUMENT CONTROL
 DC Memo 0.00
 Document Control Photocopy bluefile and create labels per PPP D407-802-017 CHG001 *Sululub*

JD for M25 11-11-14

105 0.00
105 Pick Kit
 Packaging Memo 0.00
 Packaging

SP 11-11-15.

110 0.00
110 QC4- 100% Inspect kits for completeness
 QC Memo 0.00
 Quality Control

Sululub

(te)

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|----------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* Packaging | Packaging Memo Identify and pack for shipping as per PPPD407-802-017 Location: _____ PPP rev: <u>A</u> | 0.00 0.00 | PPD76428 | | | 11/11/18 | | | |
| 130 *130* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | 11/11/19 | | | | | | |

11-11-16

Picklist Print

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Work Order ID: 76431

Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 11/14/2011






Required Date: 11/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
rev.A DD verf:EC

IPP Rev:B 10.12.03 as per dwg

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
|  D3552-17 Door Prop | | Manufactured | No | | | 105 | Each | 23.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST272 | | 11 | | | | | | | |
| | | | | 64338 | | 4 | | | | | | | |
| | | | | 65120 | | 7 | | | | | | | |
| | | | | ST276 | | 12 | | | | | | | |
| | | | | 69670 | | 12 | | | | | | | |
|  D3622-5 Ball Stud | | Manufactured | No | | | 105 | Each | 12.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST070 | | 12 | | | | | | | |
| | | | | 65087 | | 12 | | | | | | | |
|  D4108-1 Door Doubler, Left | | Manufactured | No | | | 105 | Each | 5.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | st128 | | 5 | | | | | | | |
| | | | | 62301 | | 1 | | | | | | | |
| | | | | 64484 | | 4 | | | | | | | |
|  D4108-049 Litter Door Fitting Assembly | | Manufactured | No | | | 105 | Each | 2.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST129 | | 2 | | | | | | | |
| | | | | 64490 | | 2 | | | | | | | |
|  CR3523-4-03 RIVET | | Purchased | No | | | 105 | Each | 90.0000 | 21 | 21 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST314 | | 90 | | | | | | | |
| | | | | 112991 | | 10 | | | | | | | |
| | | | | 116373 | | 80 | | | | | | | |

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Work Order ID: 76431

Parent Item: D407-802-017

Start Date: 11/14/2011

Required Date: 11/17/2011

Parent Item Name: Passenger Door Opener Installation, LH

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5

Rivet

Purchased No

105 Each 5,242.0000

2 2 SP

Location

Loc Qty

Loc Code

MEZZ

165

6733

165

ST317

5077

6874

5077

Purchased No

105 Each 73.0000

1 2x SP 1

Location

Loc Qty

Loc Code

ST302

73

117395

73

Purchased No

105 Each 5.0000

3 1x SP 3

Location

Loc Qty

Loc Code

ST304

5

104537

5

Purchased No

105 Each 68.0000

3 3x SP 3

Location

Loc Qty

Loc Code

ST293

68

115768

68

Purchased No

105 Each 128.0000

3x 1 SP 1 11-11-15

Location

Loc Qty

Loc Code

FP-B

28

17831

28

ST293

100

116290

100

1x

MS21073L5

nut plate

MS21209F1-15

HELI COIL

MS27039C1-06

Screw

MS27039C1-09

SCREW

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Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 11/14/2011

Required Date: 11/17/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-27

Screw

Purchased No

105 Each 35.0000

2 8P²

Location

Loc Qty

Loc Code

ST293

35

115768

35

NAS1149C0332R

Washer

Purchased No

105 Each 2,206.0000

2 2X SP²

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

2199

116304

55

117460

18

117887

169

118078

2

118179

78

118354

1137

119124

740

NAS1149C1165R

Washer

Purchased No

105 Each 85.0000

2 2X SP²

Location

Loc Qty

Loc Code

ST296

85

115768

85

NAS1149C0532R

WASHER

Purchased No

105 Each 281.0000

6 2X SP⁶ 11-11-15

Location

Loc Qty

Loc Code

ST297

281

116373

1

116513

53

118384

227

6X

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Shop Packet Print

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Work Order ID: 76431

Parent Item: D407-802-017

Start Date: 11/14/2011

Required Date: 11/17/2011

Parent Item Name: Passenger Door Opener Installation, LH

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0563R

Purchased

No

105

Each

370.0000

Washer

Location

Loc Qty

Loc Code

ST297

370

116391

182

117460

188

6 SP 6 11-11-15.

6X

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REFERENCE ONLY

DART AEROSPACE LTD.

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5.3 D407-802-017/-018 Passenger Door Opener Kits

| Qty -017 | Qty -018 | Part Number | Description |
|-------------|-------------|---------------|-------------------------------|
| | | D407-802-017 | PASSENGER DOOR OPENER KIT, LH |
| | | D407-802-018 | PASSENGER DOOR OPENER KIT, RH |
| | | | |
| 1 | 1 | D3552-17 | DOOR PROP |
| 1 | 1 | D3622-5 | BALL STUD |
| 1 | | D4108-1 | DOOR DOUBLER, LEFT |
| | 1 | D4108-3 | DOOR DOUBLER, RIGHT |
| | 1 | D4108-5 | SMALL RIGHT DOOR DOUBLER |
| | 1 | D4108-11 | TEMPLATE |
| | 1 | D4108-047 | SILL DOUBLER ASSEMBLY |
| 1 | | D4108-049 | LITTER DOOR FITTING ASSEMBLY |
| | 19 | CR3523-4-2 | RIVET |
| 21 | | CR3523-4-3 | RIVET |
| | 4 | CR3523-4-4 | RIVET |
| 2 | | MS20426AD4-5 | RIVET |
| | 2 | MS20426AD4-6 | RIVET |
| 1 | 1 | MS21073L5 | ANCHOR NUT |
| 3 | | MS21209-F1-15 | HELICOIL |
| 3 | | MS27039C1-06 | SCREW |
| 1 | | MS27039C1-09 | SCREW |
| 2 | 2 | MS27039C1-27 | SCREW |
| 2 | 2 | NAS1149C0332R | WASHER |
| 2 | 2 | NAS1149C1165R | WASHER |
| 6 | 6 | NAS1149C0532R | WASHER |
| 6 | 6 | NAS1149C0563R | WASHER |

5.4 D407-802-019 Baggage Door Opener Kit, Composite

| Qty -019 | Part Number | Description |
|-------------|---------------|------------------------------------|
| | D407-802-019 | BAGGAGE DOOR OPENER KIT, COMPOSITE |
| | | |
| 1 | D3552-19 | DOOR PROP |
| 1 | D4109-041 | DOUBLER ASSEMBLY, BULKHEAD |
| 1 | D4109-043 | DOUBLER ASSEMBLY |
| 3 | 80-004-2-6 | INSERT |
| 4 | MS27039C1-05 | SCREW |
| 3 | MS27039C1-06 | SCREW |
| 7 | NAS1149C0363R | WASHER |
| 4 | NAS1836-3-08M | INSERT |

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Revision: A
Date: 10.10.13

